

533

DART AEROSPACE LTD.		- Work Order :	23882
Description: 204 Skid Tube 'I' Beam		Part Number:	D2597
Drawing Ref: D2597 Rev D		Qty:	3

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg not required</i>	W	05-08-02	3
2	METAL	Cut D2500-3 to length: 84.25" Batch No. <i>B21570</i>	W	05-08-11	3
3	METAL	Use Jig DT8094 to drill pilot holes. Open to 0.625 diameter using a uni-bit.	PM	05-08-11	3
4	QA	Level 5 inspection	2	05-08-11	3
5	METAL	Acid Etch and Alodine per QSI 005 4.1	ML	05-08-17	3
6	EXPEDITING	Close W/O Job Cost			

Rev.	Date	Change	Revised By	Approved By
B	98.01.19	Change Rev of Dwg to C, Add DEO		
C	98.08.05	Updated detail	KY	
D	98.10.15	Eliminated DEO, Changed Dwg Revision	KS	<i>(S)</i>

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9-89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

Authorized Inspector

Date

RELEASED
02/09/17 RF

6	LG	Identify and stock	PM	05-8-25	3
7	AC	Cost / part <i>40.26</i>	Sys	05-08-25	3
8	DC	Close w/o <i>40.26</i> Inspect level 21	<i>(S)</i>	05/08/23	3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-08-17	4	Alodine should be before the inspection to ensure Alodine i web is completed properly permanent change				 05-08-17	2 05-08-17	

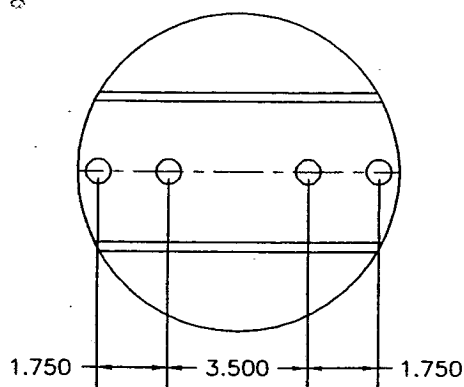
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-08-11	2	Webs A $\frac{1}{16}$ " too short, webs were cut on the line.	 05-08-11	Acceptable this time. drill sig was centered to web to compensate the $\frac{1}{16}$ " difference	 05-08-11	2 05-08-11	 05-08-11	2 05-08-11

Part No: D2597 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 23 Date: 05/08/23

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

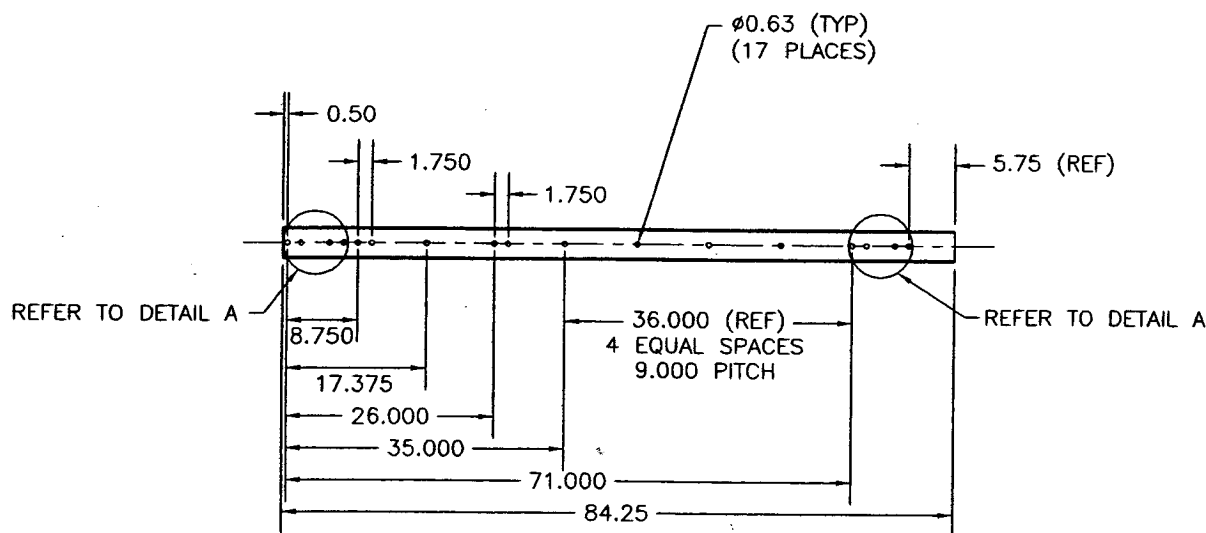
DETAIL A
SCALE 5:24



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WORK ORDER

NO. _____



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
48.9.11 JS



DESIGN	DART	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	DP	APPROVED	DP	REV. D
DATE	98.09.14	TITLE	204 WEB	SHEET 1 OF 1
A	96.09.16	NEW ISSUE		SCALE 1:24
B	96.10.29	5.75 WAS 0.50		
C	97.07.23	Ø0.63 WAS Ø0.56		
D	98.09.14	INCORPORATED DEO 9097		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____